

Work Order ID 121850

121850

Page 1

Wednesday, July 02, 2014 3:37:13 PM

Item ID: D3898-1L08 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector, Passenger (Clear)
Start Date: 6/27/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/02/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: ML5 Date: 14-07-03 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3898	B <i>ok</i>								

100 0.00 ***100*** DAS 07 9-89
HandThermo Memo 0.00 x2 14/08/07
Hand Finishing Thermoforming 1-Cut Sheet to required Blank size

105 0.00 ***105*** DAS 07 9-89
HandThermo Dry material 0.00 x2 14/08/07
Hand Finishing Thermoforming Memo Dry Sheet as per QSI022 POLYCARBONATE
Temp: **245 deg. F** **AUG 07 2014**
Time IN: **5:00 PM**
Time OUT: **6:00 AM** Per.....

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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[illegible]

DQA: _____ Date: _____



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Wednesday, July 02, 2014 3:37:13 PM

121850

Page 3

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160	QC5- Inspect part completeness to step on W/O	0.00							
160						2		DAS 16 14/08/12	DAS 38 14/08/12
QC	Memo	0.00						9-89	9-89
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170						2x		DAS 28 AUG 12 2014	
Packaging	Memo	0.00						9-89	
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 14-08-12
MLJ 14-08-12

DQA: _____ Date: _____



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		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

Thursday, July 03, 2014 9:20:10 AM

Page 1

Work Order ID: 121850

121850

Parent Item: D3898-1L08

D3898-1L08

Parent Item Name: Floor Protector, Passenger (Clear)

Start Date: 6/27/14

Required Date: 7/02/14

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev. C Color code added to D3898-1 14/07/02 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.118-90318-08

Purchased

No

sf

2,885.788

21.2

DAS

MI FXS 118-90318-08

07

9-89

Lexan Sheet

Location

Loc Qty

Loc Code

therm

2885.788

113127

8

m126994

2877.788

17/02/07

21.2 sg ft.

DQA: _____ Date: _____



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Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
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Unapproved <input type="checkbox"/>									

FAULT CATEGORY

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DART AEROSPACE LTD		Work Order: 121850
Description: Floor Protector		Part Number: D3898-1
Inspection Dwg: D3898	Rev: A03	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DAS 07 9-89	Date: 14/08/07
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	Min	0.53"	✓			
1.00	Min	1.02"	✓			
5.6	+0.2/-0.0	5.6"	✓			
0.080	Min	0.087"	✓			
0.050	Min	0.060"	✓			

Measured by:	DAS 07 9-89	Date: 14/08/11
Audited by:	DAS 38 9-89	Date: 14/08/12
Prototype Approval:	N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

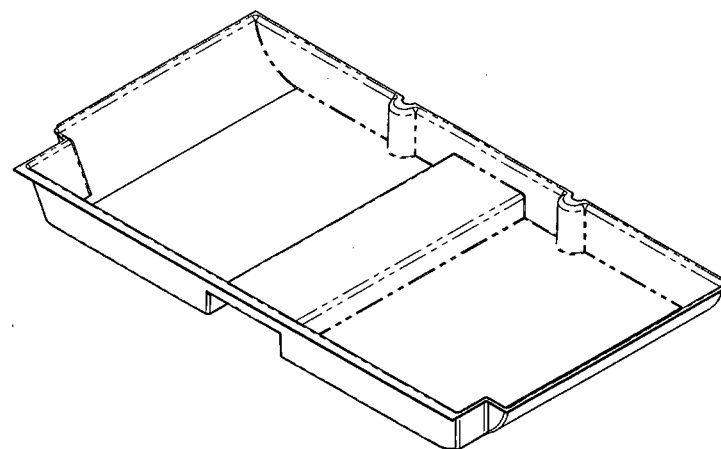
Work Order update only ☐

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D3898-1LXX FLOOR PROTECTOR (206L)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121850 M.C.J.
1407-03

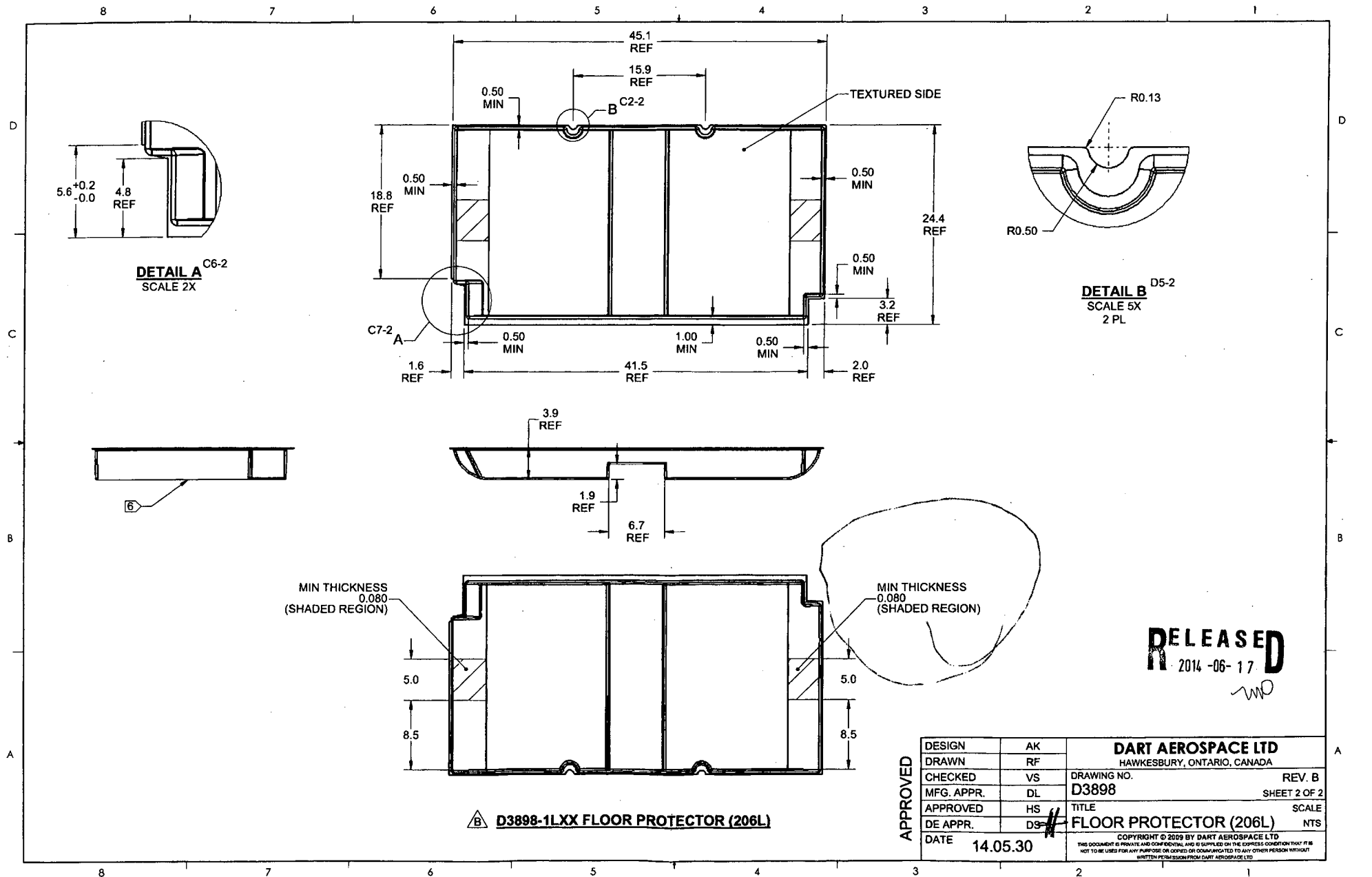
RELEASED
2014-06-17
mp

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1LXX" PER DART QSI 044 METHOD 6.4
 - 7) WEIGHT: 5.0 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

PART NUMBER		DESCRIPTION
D3898-1L02		F8006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEX.125-F6006-02)
D3898-1L08		90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEX.118-90318-08)

B	ADDED D3898-1L02 CONFIGURATION AND RE-IDENTIFIED D3898-1 AS D3898-1L08. REVISED NOTE 1 AND ADDED MATERIAL TABLE.	AK	14.05.30
A	NEW ISSUE	PH	09.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DL	D3898	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FLOOR PROTECTOR (206L)	NTS
DATE	14.05.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

APPROVED



RELEASED
2014-06-17